

DUPLICATE

Dart Aerospace Ltd.

Date: Wednesday, 22/08/2007 11:38:25 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 33878		
Estimate Number	: 10791		
P.O. Number	: <i>N/A</i>	Part Number	: D3282041
This Issue	: 22/08/2007	Drawing Number	: D3282 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 13/08/2007	Drawing Revision	: C
Previous Run	: 33877	Material	: <i>N/A</i>
Written By	: <i>U</i>	Due Date	: 20/08/2007
Checked & Approved By	: <i>U</i>	Qty:	4
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

B33518 AWM 07/08/13

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

AWM - 07/08/13

Cut to length as per Dwg D3282.

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

J.F. Aml 07/08/17 (4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. Aml 07/08/17 (4)

Date: Wednesday, 22/08/2007 11:38:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33878

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

51 07/08/23

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11 7-8-23 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-8-23 (4)

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number
2 D3283-1

Description
Doubler

Batch

B 33.717 (9)

11 7-8-23

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 228.0000 Each(s)

Pick:

Qty Part Number
57 MS20470AD4-7

Description
Rivet

Batch

M104291 11 7-8-23

(285)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M103674

11 7-8-23 (P10) →

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

End 07/09/06 (84)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: N/A Fault Category: Prod / Landing Gear NCR: Yes No DQA: D Date: 07/09/10
 QA: N/C Closed: JA Date: 07.09.11

NCR: <u>33878</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/24	#100	Rivets were installed in I Beam (P/N D3282-041) but one doubler was forgotten E.C. Human Error	[Signature] 051042	Remove all 57 Rivets AND Doubler	[Signature] 28-24	[Signature] 07/06/24	[Signature] 051042	En 07/06/24
				Remove any Barbs and marks	[Signature] 28-24			
				QC inspect	→			
			[Signature] 051042	Re Alodine interior web	[Signature] 28-24	En 07/06/24	[Signature] 051042	↓
				Reinstall Rivets and BOTH Doubler as per AND Buckle LPS-3	[Signature] 28-24			
07/09/06	#11	Original w/o was found its Attach to the sub	[Signature] 051042	Attach to this original w/o	[Signature] 07/09/06	[Signature] 07/09/06	[Signature] 051042	En 07/09/06

NOTE: Date & initial all entries

Date: Wednesday, 22/08/2007 11:38:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33878

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L-6

R 7-9-6

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④
D 07/09/10

Job Completion



U 07/09/07

Date: Wednesday, 22/08/2007 11:37:19 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 33878	Customer	: Dart Helicopters Services
Estimate Number	: 10791	DWG Name	: FLOAT WEB
Purchase Order #	:	Part Number	: D3282041
Complete Date	: / / : : AM	DWG Number	: D3282 REV C
		Rev.	: C

DUE DATE	ORDERED	DELIVERED
20/08/2007	4	0

2.0 LANDING GEAR 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
13/08/2007	MAHE01: Maheu, Andrew	Run	0.000	1.15	\$18.93	2.29	47.49
13/08/2007	MAHE01: Maheu, Andrew	Run	8.000	0.00	\$0.00	0.00	0.00

Subtotal:	QTD:	8	CTD:	0	1.15	\$66.42
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3.0 HAAS1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
17/08/2007	SAUV01: Sauve, Jean-Francois	Run	0.000	3.59	\$65.09	3.59	102.84
18/08/2007	LAMA01: Lamarche, Mathieu	Run	0.000	7.16	\$129.81	7.16	205.10
19/08/2007	LAMA01: Lamarche, Mathieu	Run	4.000	3.81	\$69.08	3.81	109.15

Subtotal:	QTD:	4	CTD:	0	14.56	\$681.07
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		TIME	COST
	Machine Time:	16.85	\$464.58
	Labor:	15.71	\$282.91
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$0.00
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$747.49

COST PER UNIT:	\$747.49
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Date: Monday, 8/13/2007 1:07:06 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 33878	
Estimate Number : 10791	
P.O. Number :	Part Number : D3282041
This Issue : 8/13/2007 S.O. No. :	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1	Drawing Revision : C
Previous Run : 33877	Material :
Written By : <i>[Signature]</i> 02-08-13	Due Date : 8/20/2007 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

B-33518 ANM 07/08/13

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

ANM 07/08/13

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

ML/J.F. 07/08/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML/J.F. 07/08/17

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33878

Part Number: D3282041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D32831 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3283-1	Doubler	

9.0 MS20470AD47 Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 228.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
57	MS20470AD4-7	Rivet	

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Monday, 8/13/2007 1:07:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33878

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

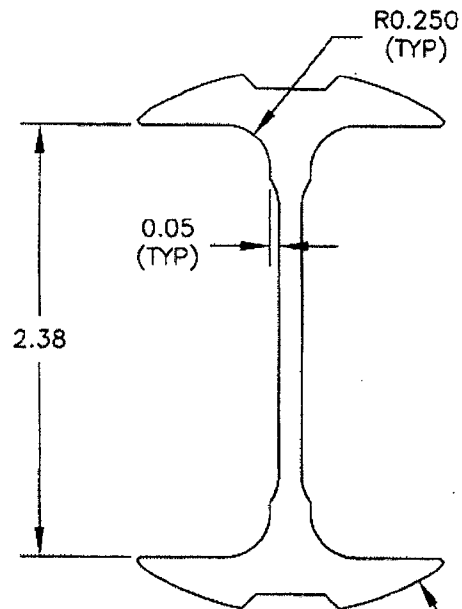
Job Completion



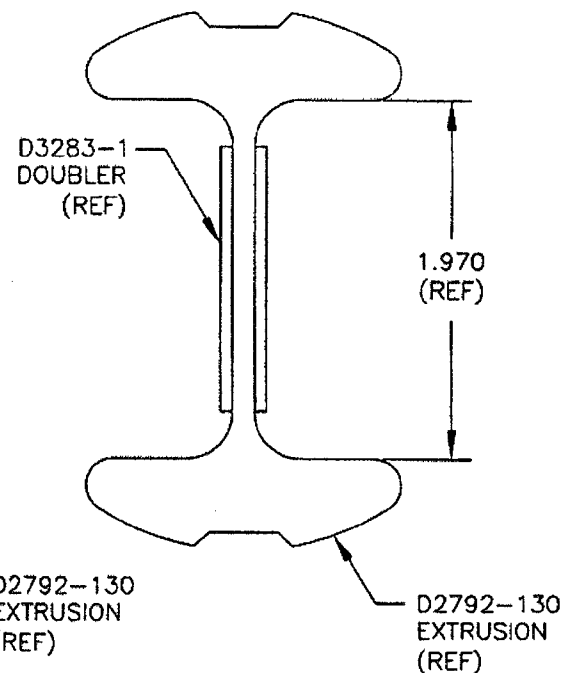


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE	1:20	

SECTION A-A

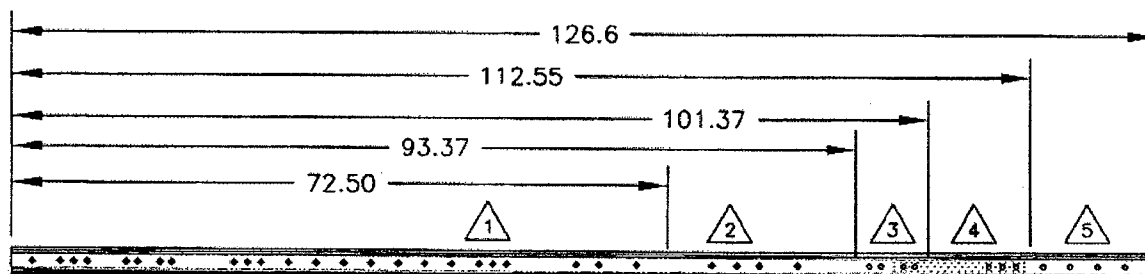


SECTION B-B

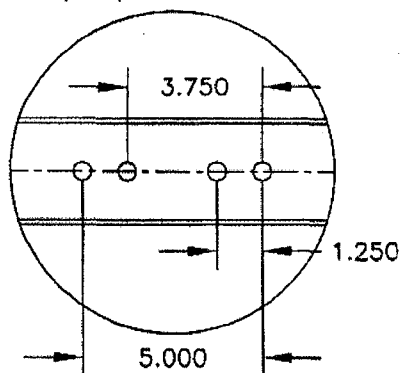
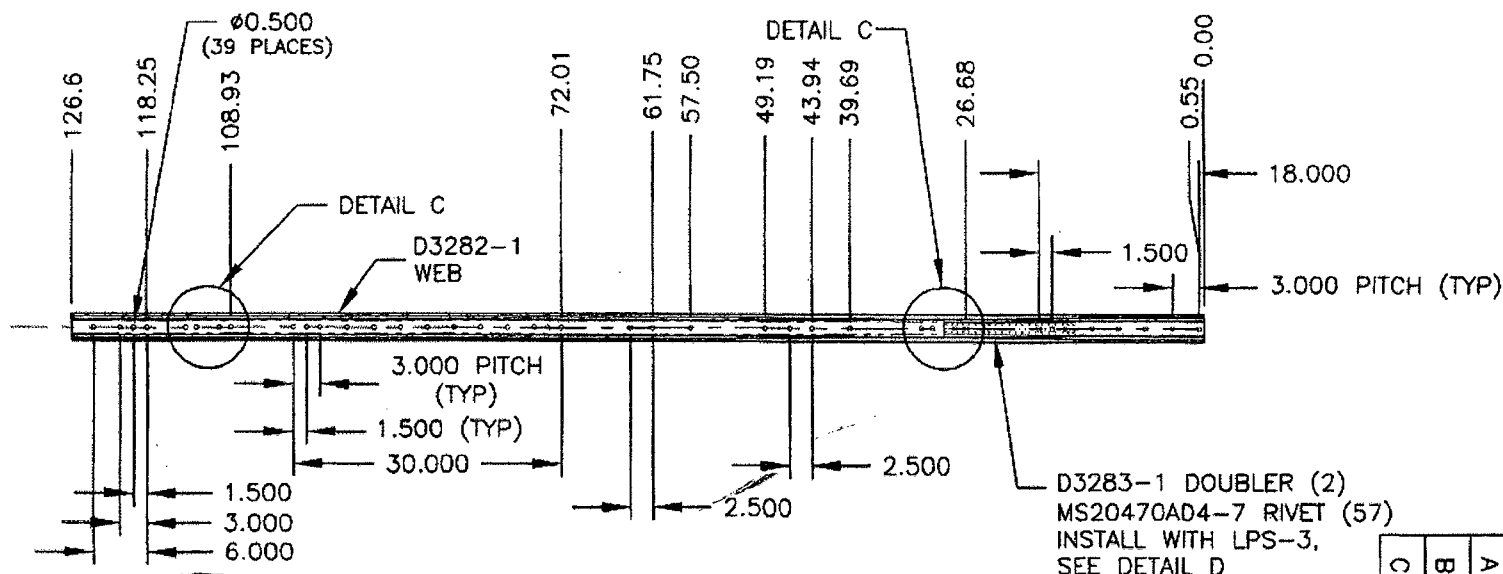


D3282-1 MACHINING NOTES

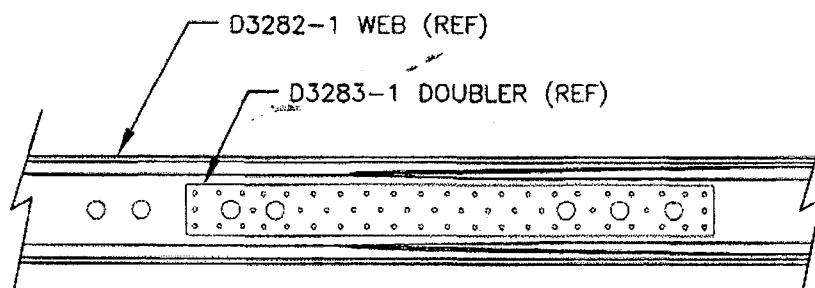
- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-09-12



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3282
DATE		TITLE
05.08.09		FLOAT WEB, 206L/407
	A	04.05.05
	B	05.03.16
	C	05.08.09
		NEW ISSUE
		MOVE HOLES, ADD D3390-1 DOUBLERS
		REMOVE D3390-1, NOW MACHINED
		SCALE
		1:20
		REV. C
		SHEET 1 OF 2

RELEASED

05.09.12

DART AEROSPACE LTD		Work Order: 33877
Description: Float Web		Part Number: 03282-1
Inspection Dwg: 03282 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	±.050"	±.030"	0.40"	✓		
B	±.030"	±.030"	2.376"	✓		
C	±.010"	±.010"	R.250"	✓		
D	±.030"	±.030"	.556"	✓		
E	±.010"	±.010"	3.002"	✓		
F	±.010"	±.010"	3.749"	✓		
G	±.010"	±.010"	1.249"	✓		
H	±.010"	±.010"	4.998"	✓		
I			0.501"	✓		
J	±.010"	±.010"	1.499"	✓		
K	±.010"	±.010"	2.500"	✓		
L	±.010"	±.010"	5.995"	✓		
M	±.100"	±.100"	126.6	✓		
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 07/08/16	Date: 01.08.16	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved